

303 R.625

SPLIT

93660

Work Order ID 93660-1

November-22-12 1:34:33 PM

Item ID: D3873-1

Revision ID:

Item Name: Bushing

Start Date: 21/11/2012 Start Qty: 400.00

Required Date: 20/12/2012 Req'd Qty: 400.00

Reference:

Approvals: Process Plan: ML5

QC:

Accept

400

400

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Date: 12-11-22 Tooling: Date: Run Start *NR1*
Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3873	C
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100	0.00
-----	------

100

Hardinge	Memo	0.00
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Hardinge CNC Lathe Small

I-TURN AS PER FOLIO FA806 & DWG D3873,
FOLIO REV: W/A
DWG REV: C

2-DEBURR AS REQUIRED

110	QC2- Inspect parts off machine FAI/FAIB	0.00
-----	-----------------------------------------	------

110

QC	Memo	0.00
----	------	------

Quality Control

12.12.20

130
272DAS
04
8-8

12.12.20

130
272DAS
04
8-814
125

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____	<input type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update		Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio				<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			
							<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge			<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled
										<input type="checkbox"/> Other

Work Order ID 93660

November-22-12 1:34:33 PM

93660

Page 2

Item ID: D3873-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Bushing

Stop

NS2

Start Date: 21/11/2012 Start Qty: 400.00

400

Cust Item ID:

Required Date: 20/12/2012 Req'd Qty: 400.00

400

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

120

120

QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

145
33
00

130

Identify as per dwg & Stock Location: ST069

0.00

130

Packaging

Packaging

Memo

0.00

8/13/01/02

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

13/11/10/08

WWT
11/10/08

NCR: Yes / No

DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
				Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>					
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector	
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												<input type="checkbox"/> Other	

Picklist Print

November-22-12 1:34:37 PM

Page 1
T

Work Order ID: 93660

93660
D3873-1

Parent Item: D3873-1

Parent Item Name: Bushing

Start Date: 21/11/2012

Required Date: 20/12/2012

Start Qty: 400.00

Required Qty: 400.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.625		Purchased	No			100	f	217.7982	0.06	25.26316			**

M303R0 625

303 Round Bar 0.625"

Location	Loc Qty	Loc Code
MAT028	217.79821	
118400	2	
119009	59.79821	
119766	156	

12.12.20
DAS
04
8-99

279
15.42/
29
15.42/
29
15.42/

2408 7.877
7.877

233

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

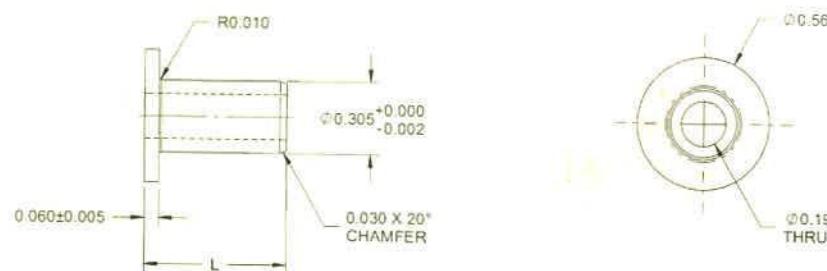
Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS														
Part No. _____	Work Order Update	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Prod. Eng. Ccor. <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/>	Quality <input type="checkbox"/>	Other <input type="checkbox"/>
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification		QC Inspector							
Doc/Data																			
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DART AEROSPACE LTD	Work Order:	93660
Description: Bushing	Part Number:	D3873-1
Inspection Dwg: D3873 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	<i>AS</i>	Audited by:	<i>BG</i>	Preliminary Approval:	
Date:	12/12/18	Date:	12.12.30		Date:

Rev	Date	Change	Revised by	Approved
A	09.05.20	New Issue	KJ	
B	10.11.05	Dimensions updated per Dwg Rev B	KJ	
C	12.02.01	Dwg Rev updated	KJ	JK



D3873-X BUSHING

C

DART P/N	L	WEIGHT (lbs)
D3873-1	0.600	0.010
D3873-3	0.120	0.005
D3873-5	0.270	0.007

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES. 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: PER TABLE

8 7 6 5 4 3 2 1

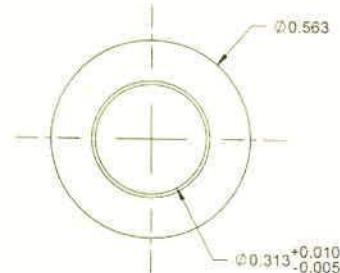
THE DART
CORPORATION
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHDRAWN NOTICE
WORK ORDER

93660 MLJ
12-11-22

RELEASED
2011-09-12
JP

C	ADD D3873-3/5/-7 (ZN B6-1 & B5-2)	RF	11.06.14
B	Ø0.563 WAS Ø0.63 (C3-1. TO FIT TRIBAG GIRT)	CP	10.07.22
A	NEW ISSUE	MB	09.01.07
REV	DESCRIPTION		
DESIGN	CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	PP	DRAWING NO.	REV. C
MFG. APPR.	EE	D3873	SHEET 1 OF 2
APPROVED	MM	TITLE	SCALE
DE APPR.	MM	BUSHING	NTS
DATE	11.06.14	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS THE PROPERTY OF DART AEROSPACE USA, INC. IT IS PROHIBITED THAT IT BE NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

93600



△ D3873-7 SPACER

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.005 lbs
- 8) IT IS ACCEPTABLE TO BE DEBURR

8 7 6 5 4 3 2 1

DESIGN	RF	DART AEROSPACE USA, INC.
DRAWN	RF	PORT HADLOCK, WA
CHECKED	✓	DRAWING NO.
MFG APPR.	✓	REV. C
APPROVED	✓	D3873
DE APPR.	✓	SHEET 2 OF 2
DATE	11.06.14	TITLE
		SCALE
		NTS
		BUSHING

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RELEASED
2011-09-12
AN

